



Dart Hawkesbury
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Canada

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D4653-7

Job Sheet 168527



Part No: D4653-7

Job Qty: 22 ea

Part Name: Fitting, Large



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/16/17

Job Tracking No:

Due Date: 11/24/17

Created By: Mario Poulin

Type: SOLD

Description:

Note: DWG REV A IPP REV A NEW ISSUE 12-06-11 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	22 Ea		11/23/17	0.00	0.00	Start Up Machining		17/12/07
100	Doosan	22 pcs		11/24/17	0.26	4.07	Doosan		17/12/07
120	QC	22 pcs		11/24/17	0.00	0.00	QC8		17/12/11
130	Packaging	22 pcs		11/24/17	0.00	0.00	Packaging3	WAC02	
140	QC21-SA	22 Ea		11/24/17	0.00	0.00	QC21		

DAS
21
DEC 13 2017

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6R1.000	4	62	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Large Fitting	1.380Inches $\pm$ 0.030	1.410 1.350		
2	Large Fitting	0.250Inches $\pm$ 0.010	0.260 0.240		
3	Large Fitting	45.000Degrees $\pm$ 0.500	45.500 44.500	Angle	
4	Large Fitting	0.0940inches $\pm$ 0.0300	0.1240 0.0640	Radius	
5	Large Fitting	2.120Inches $\pm$ 0.030	2.150 2.090		
6	Large Fitting	0.825Inches $\pm$ 0.010	0.835 0.815	Diameter	
7	Large Fitting	0.547Inches $\pm$ 0.010	0.557 0.537	Diameter	
8	Large Fitting	0.0990inches $\pm$ 0.0100	0.1090 0.0890		
9	Large Fitting	0.745Inches + 0.000 - 0.005	0.745 0.740	Diameter	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS			
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
		Large Fab ☐	Composite ☐	Supplier ☐		

Date : _____ Step #: _____

Description Work Order

DART
AEROSPACE
S018476



Fitting, Large

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CANADA
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Email: sales@dartaero.com
www.dartaerospace.com

MRB (QSI042) Approval

Completed By

Lead hand / Supervisor
Approval Verification

QC / QA Coordinator
Approval

PART NO:
Revision:
Operation:
Change No:

D4653-7

Start up Operation

Mfg Date: 12/07/17
Job No: 168527

Root Cause			
Environment ☐	No Re-verification ☐	Cracks ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Crimp/Kink/Ripple/Wave ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Cuffs ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Crushing ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Heat Treat ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Wave/Twist in Tube ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Marks/Chatter ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐		Finish ☐
LOA ☐	Product Improvement ☐		Misread ☐
Substation ☐	Process Improvement ☐		Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐		
Misidentified ☐	Past Due ☐	OTHER : _____	

